

Date: Monday, 12/11/2006 12:54:01 PM
 User: Kim Johnston

Process Sheet

| | | | | | |
|-----------------------|---|----------------|------------------|---------------|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : BUSHING | |
| Job Number | : 29847 | | Part Number | : D28063 | |
| Estimate Number | : 10518 | | Drawing Number | : D2806 REV A | |
| P.O. Number | : N/A | | Project Number | : N/A | |
| This Issue | : 12/11/2006 | S.O. No. : N/A | Drawing Revision | : A | |
| Prsht Rev. | : NC | | Material | : N/A | |
| First Issue | : N/A | | Due Date | : 12/23/2006 | |
| Previous Run | : 29394 | | Qty: | 72 | |
| Written By | | | Um: | 20 Each | |
| Checked & Approved By | | | | | |
| Comment | : Est:B 05/03/11 Part now turned KJ/JLM | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|---------|-----------------------|---|--|
| 1.0 | M6061T6H1000 | 6061-T6 1" HexBar | |
| | | Comment: Qty.: 0.0962 f(s)/Unit Total : 1.9236 f(s) 6061-T6 Hex Bar 1.0" Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.00" Hex Bar (M6061T6H1.000) | |
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL | |
| | | Comment: HARDINGE CNC LATHE SMALL 1-Turn as per Folio FA105 and Dwg D2806 2-Tumble | |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE | |
| | | Comment: INSPECT PARTS AS THEY COME OFF MACHINE | |
| 4.0 | MILLING CONV. | CONVENTIONAL MILLING MACHINE | |
| | | Comment: CONVENTIONAL MILLING MACHINE Drill as per Dwg D2806 | |
| 5.0 | QC8 | SECOND CHECK | |
| | | Comment: SECOND CHECK | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/01/15
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|----------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 12/11/2006 12:54:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 29847

Part Number: D28063

Job Number:



Seq. #: Machine Or Operation:

Description :

(72)

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HL

07/01/15

(72)

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

PL 07/01/15 (72)

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 54387

PL 07/01/15 (72) / 07/01/15

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

PL 07/01/15 (72)

Job Completion



PL 07/01/15

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

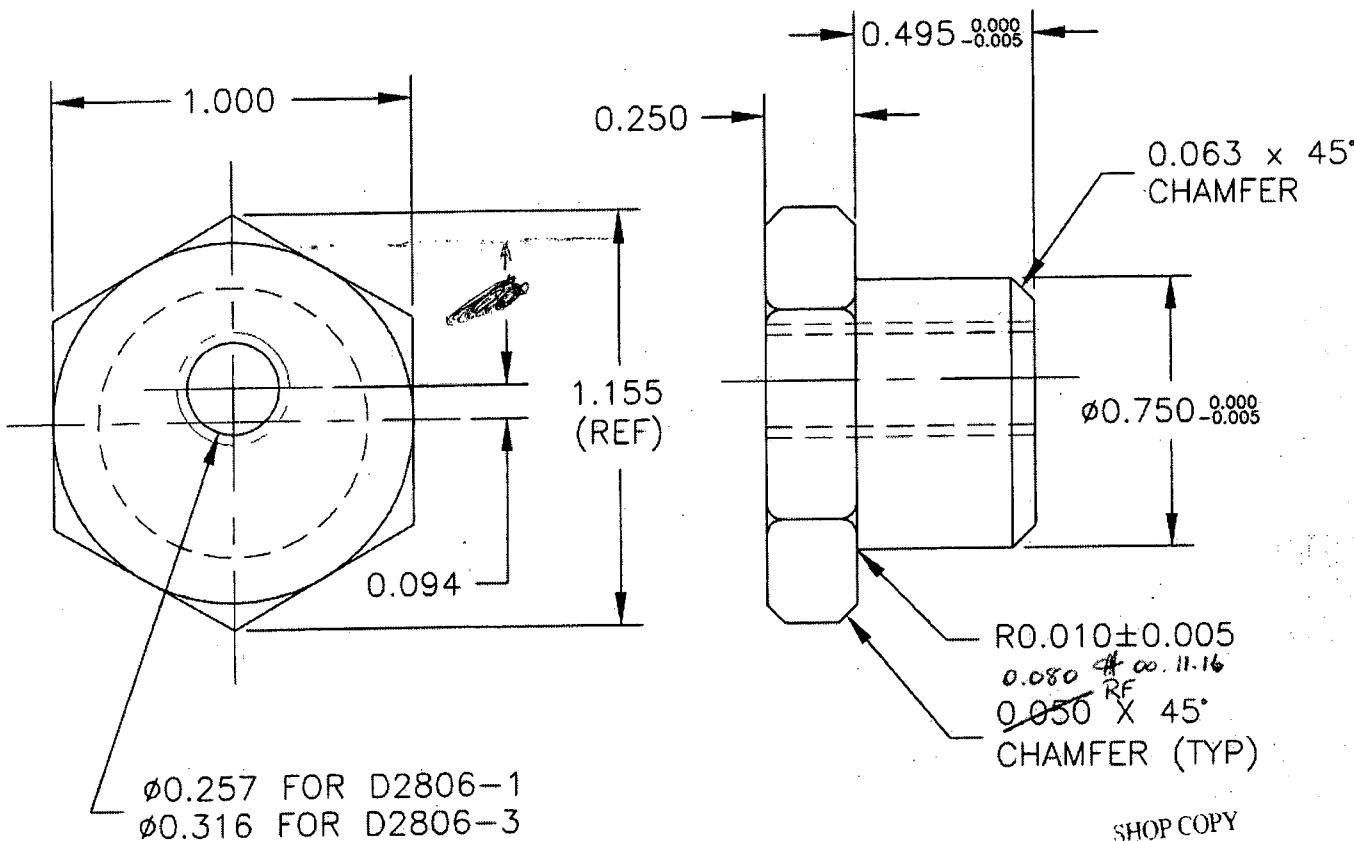
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART

| | | | |
|----------|----------|---|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. | REV. A |
| CP | # | D2806 | SHEET 1 OF 1 |
| DATE | TITLE | | SCALE |
| 00.11.08 | BUSHING | | 2:1 |
| A | 00.11.08 | NEW ISSUE | |

RELEASED
00.11.13 #



$\phi 0.257$ FOR D2806-1
 $\phi 0.316$ FOR D2806-3

D2806-1 (DRILL $\phi 0.257$ HOLE)
D2806-3 (DRILL $\phi 0.316$ HOLE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29847

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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| | | |
|------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 09847 |
| Description: | Part Number: | D28063 |
| Inspection Dwg: , Rev: | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

DSP 07/01/03
Measured by: *S. A. B.*
Date: 07/01/03

Measured by: S. S. F.
Date: 07/01/06

| | |
|-------------|----------|
| Audited by: | J.L. |
| Date: | 07/01/07 |

| | |
|----------------------------|-----|
| Prototype Approval: | |
| Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |